

Work Order ID 70038

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Wednesday, May 25, 2011 1:03:31 PM

Item ID: D3372-1

Accept



Setup Start



Revision ID:

Item Name: Main Body

Stop



Start Date: 5/25/2011 Start Qty: 4.00



Cust Item ID:

Required Date: 6/10/2011 Req'd Qty: 4.00



Customer:

Reference:

Approvals: Process Plan: CL

Date: 11/04/25

Tooling:

Date:

Run Start



QC: _____

Date: _____

SPC (Y/N):

Date: _____

Stop


**Sequence ID/
Work Center ID**
**Operation
Description**
Set Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr	Revision Nbr
D3372	Rev B

100 0.00



BAND SAW

Bandsaw

Memo

0.00

CL 11/07/07

4 8

Jeaspa Bandsaw

Cut blank: 1.500" x 3.000" x 4.450" long

110



HAAS CNC VERTICAL MACHINING #1

0.00

HAAS 1

Memo

0.00

HAAS CNC vertical machine #1

Machine D3372-1 as per Folio FA496 and Dwg D3372
 Identify as D3372-1
 Deburr

A.A 11/07/14

4 Ø

120



QC2- Inspect parts off machine FAI/FAIB

0.00

QC

Memo

0.00

Quality Control

A.A 11/07/14

4 Ø

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Customer:

Reference:

Approvals: Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start



QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

**Sequence ID/
Work Center ID****Operation
Description**Set Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

QC8- Inspect parts - second check

0.00

mkl/11/07/15

4 9



QC

Memo

0.00

Quality Control

140

Chemical Conversion Coat per QSI005 4.1

0.00

4 6 11-7-18



HandFinish

Memo

0.00

Hand Finishing

150

Fire Red(Ref.4.3.5.10) per QSI005 4.3

0.00

4 6 11-7-18



Powdercoat

M 102301

Memo

0.00

Powder Coating

Mask all holes and interior of the big hole

START TIME: 2:15

OVEN TEMPERATURE: 320°

FINISH TIME: 3:15

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Item ID: D3372-1

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Setup

Start



Revision ID:

Item Name: Main Body

Stop



Start Date: 5/25/2011 Start Qty: 4.00



Cust Item ID:

Required Date: 6/10/2011 Req'd Qty: 4.00



Customer:

Reference:

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start
	QC:	Date:	SPC (Y/N):	Date:	Stop	



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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160 QC3- Inspect Part Finish

0.00



QC

Quality Control

4/10/2011

170



Packaging

Packaging

Identify as per dwg & Stock Location SA

0.00

8/10/12

(4)

180



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

11/10/13 JF

MF
11-10-13

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Wednesday, May 25, 2011 1:03:28 PM

Page 1

Work Order ID: 70038



Parent Item: D3372-1



Parent Item Name: Main Body

Start Date: 5/25/2011

Required Date: 6/10/2011

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP A□05.01.18□New issue□KJ/JLM□

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6B30000X01.5 00		Purchased		No		100	f	22.5880	0.375	1.578947			

6061-T6 Bar 3.00 x 1.50



Location	Loc Qty	Loc Code
MAT010	22.588	
109058	1.667	
→114468	10.5	
117653	10.421	

1.58

on 1/10/2007

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

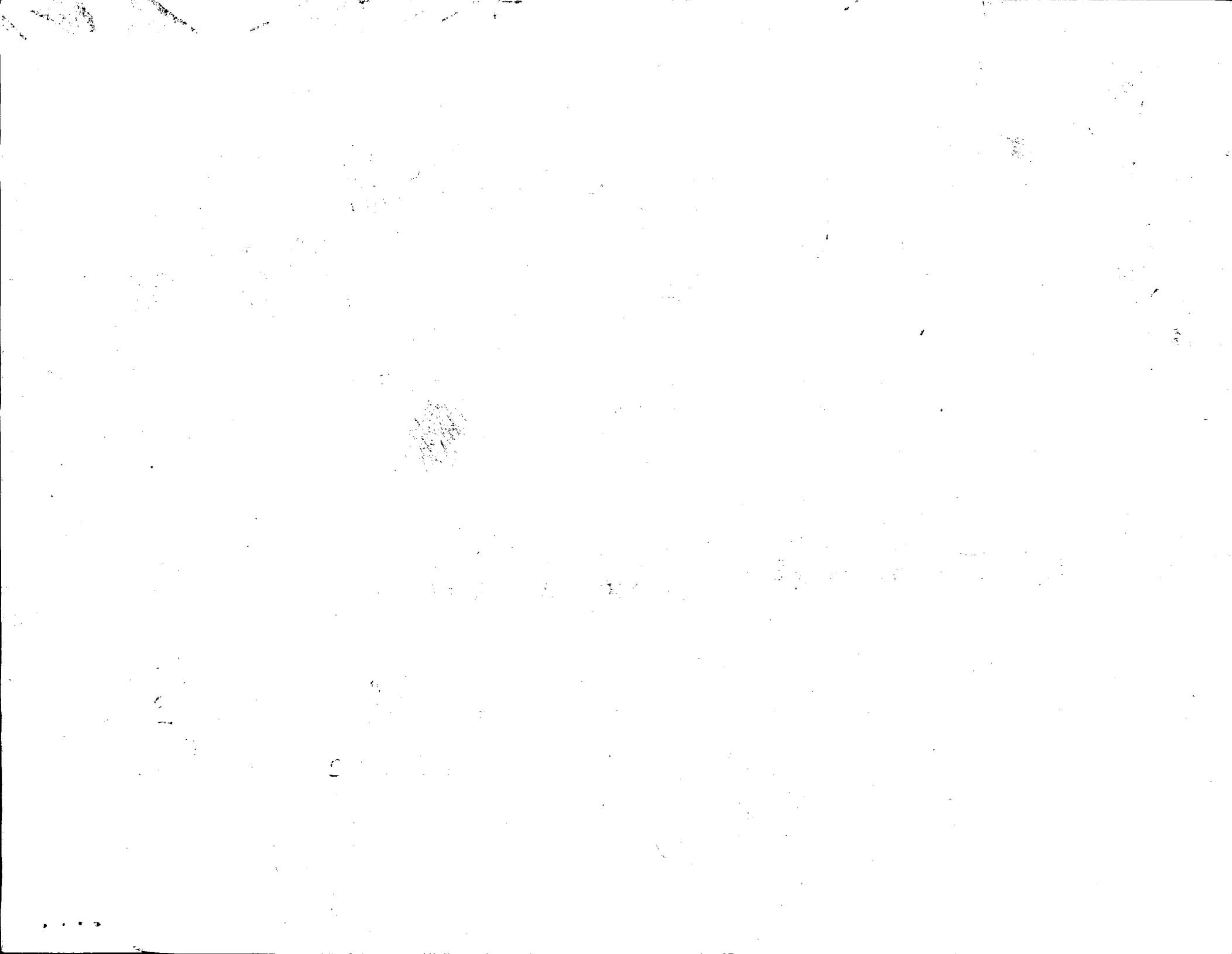
DART AEROSPACE LTD	Work Order:	70038
Description: Main Body	Part Number:	D3372-1
Inspection Dwg: D3372	Rev: B	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Measured by:	B.A.	Audited by:	<u>cmk</u>	Prototype Approval:	N/A
Date:	11/07/14	Date:	11/07/15	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	05.04.26	New Issue	KJ/JLM	
B	08.09.09	Dimensions revised	KJ/DD	

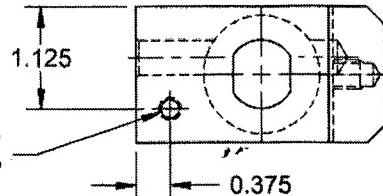




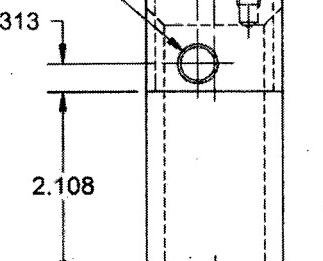
DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO.	REV. B
DATE	05.02.23	TITLE	SHEET 4 OF 8 COLLECTIVE LOCK 1:2

RELEASED
05/04/26

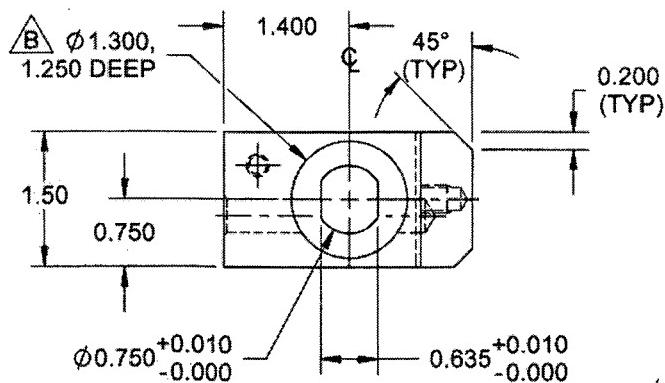
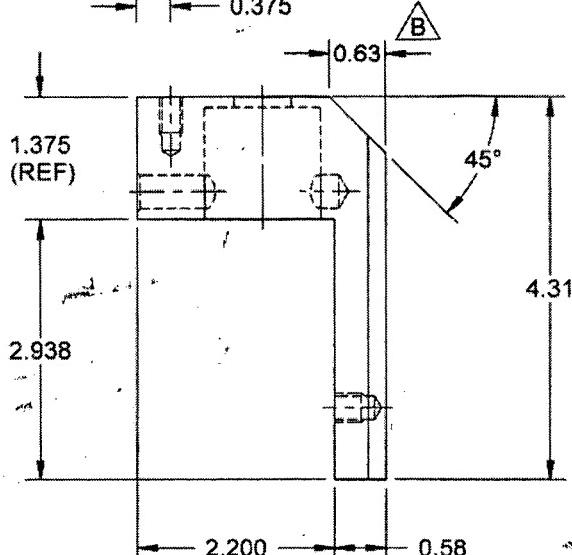
△ DRILL Ø 0.201 x 0.600 DEEP
② TAP 1/4-20 UNC x 0.400 DEEP



△ DRILL Ø 0.377,
2.363 DEEP,
CHAMFER 0.031 x 45°



△ DRILL "I" DRILL
x 0.525 DEEP
THREAD 5/16-24 UNF
x 0.300 DEEP



D3372-1 MAIN BODY

CL 11/05/25

W/D: 70038

NOTES:

- 1) MATERIAL: 6061-T6/T651 (QQ-A-200/8 OR QQ-A-225/8)
(REF. DART SPEC. M6061T6B)
- 2) COVER INSIDE HOLES PRIOR PAINTING
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005-4.1
POWDER COAT FIRE RED (4.3.5.10) PER DART QSI 005-4.3
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010

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